

Plaslube® PA6/6 CF30 TS12 BK

Techmer Polymer Modifiers - *Polyamide 66*

General Information

General			
Material Status	• Commercial: Active		
Availability	• North America		
Filler / Reinforcement	• Carbon Fiber, 30% Filler by Weight		
Additive	• PTFE Lubricant: 15%	• Silicone Lubricant	
Features	• Low Friction	• Lubricated	• Wear Resistant
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.34		ASTM D792
Molding Shrinkage - Flow (0.125 in)	4.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.45	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	27100	psi	ASTM D638
Tensile Elongation (Break)	2.5	%	ASTM D638
Flexural Modulus	1.87E+6	psi	ASTM D790
Flexural Strength	38200	psi	ASTM D790
Coefficient of Friction			ASTM D1894
vs. Steel - Dynamic	0.11		
vs. Steel - Static	0.10		
Wear Factor	6.0	10 ⁻¹⁰ in ³ ·min/ft·lb·hr	ASTM D3702
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	1.2	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	490	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	485	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	540 to 560	°F
Middle Temperature	550 to 570	°F
Front Temperature	530 to 550	°F
Nozzle Temperature	520 to 580	°F
Processing (Melt) Temp	540 to 580	°F
Mold Temperature	175 to 220	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi

Injection Notes

Screw Speed: Slow
 Recommendations for Molding and Tool Conditions: Well vented mold
 Moisture Content, as received: Product is packaged at 0.2% or less.

